



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1**Job Sheet 190683****Part No:** D3278-1**Job Qty:** 60 pcs**Part Name:** Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/13/19**Job Tracking No:****Due Date:** 3/8/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs		3/8/19	0.00	1.73	Bandsaw - 1		BM
110	HAAS 5 Axis - B4B	60 pcs		3/8/19	0.06	18.82	HAAS - 5 - B4B		
120	Outsource - 5 - Machining	60 pcs		3/8/19			MEM001-VC		CC 19-3-d
125	Packaging 2-1 - Receive - B4B	60 pcs		3/8/19	0.00	0.00	Packaging 2 - 1 - B4B		 APR 02 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		

**Container No:** S157813**Part:** D3278-1**Job No:** 190683**Serial No/Batch:** S157813**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 2/13/19 10:40 AM Dart.lajeunesse.marie

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
130 QC 6	60 pcs	3/8/19	0.00 0.00	QC 6 - 42	DAS	
				QC 6 - 9	APR 02 2019 40	
				QC 6 - 68	9-89	
				QC 6 - 61		
140 Handfinish - 1-1 Chemical-B4B	60 pcs	3/8/19	0.00 0.57	Handfinish - 1 - 1 - B4B	BEB 19-04-02	
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150 Powdercoat - 1 White Gl(A)-B4B	60 pcs	3/8/19	0.00 0.45	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160 QC 3	60 pcs	3/8/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		

Plex 2/13/19 10:40 AM Dart.lajeunesse.marie

				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170	Packaging 3-1 - Stock - B4B	60 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
180	QC 21 - SA	60 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long Descriptions: 110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1 120 - (Outsource process - Machining) 125 - (Receive & Inspect for Damage & Mat'l Certs)					

130 - (QC6- All purchased or subcontracted products)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13.0200 ft (.217 ea)	100-Bandsaw - 1	S157420

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	13	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359inches ± 0.005	0.364 0.354		
3	Support	0.609inches ± 0.010	0.619 0.599		
4	Support	0.250inches ± 0.010	0.260 0.240		
5	Support	1.480inches ± 0.005	1.485 1.475		
6	Support	0.125inches ± 0.010	0.135 0.115		
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115		
8	Support	2.439inches ± 0.010	2.449 2.429		
9	Support	1.980inches ± 0.010	1.990 1.970		
10	Support	0.130inches ± 0.030	0.160 0.100		
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257		
12	Support	0.375inches ± 0.010	0.385 0.365		
13	Support	0.875inches ± 0.010	0.885 0.865		
14	Support	0.500inches ± 0.010	0.510 0.490		
15	Support	0.400inches ± 0.010	0.410 0.390		
16	Support	1.000inches ± 0.030	1.030 0.970		
17	Support	1.720inches ± 0.010	1.730 1.710		
18	Support	0.125inches ± 0.010	0.135 0.115		
19	Support	0.125inches ± 0.010	0.135 0.115		

Plex 2/13/19 10:40 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042758



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042758

PO Date: 3/1/19

Due Date: 4/2/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190685	D3278-2	Support : Various STC's	Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
	190684			Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
Sub Total:							120	0	120		\$3,006.00
2	190683	D3278-1	Support : Various STC's (Outsource process - Machining)	Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
	190682			Firmed	-	4/2/19	60 pcs	0 pcs	60 pcs	\$25.05/pcs	\$1,503.00
Sub Total:							120	0	120		\$3,006.00
Grand Total:											\$6,012.00

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042758



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A handwritten signature in black ink, likely belonging to Patrick Lussier, is written over the bottom right of the Order Notes section.

Plex 4/1/19 2:33 PM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24909
Shipment Date: 28-Mar-2019
Ship Via: Pick up at METEC
Order Number: 3559
Order Date: 03/01/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042758 ✓
Terms: Net 60 Days

----- Quantity -----									Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>	
3	120	120 ✓	0	0	EA	D3278-2P Support, unpainted	C	3559-01	
4	120	120 ✓	0	0	EA	D3278-1P Support, unpainted	C	3559-02	

DAS
40
9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
60	D3278-1	Support	C	S157799	Unpainted	42758
60	D3278-2	Support	C	S157799	Unpainted	42758
60	D3278-1	Support	C	S157813	Unpainted	42758
60	D3278-2	Support	C	S157813	Unpainted	42758

DAS
40
9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, March 28, 2019